

Work Order ID 66090

February 4, 2011 7:33:46 AM



Page 1

Item ID: D3907-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 2/04/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CD Date: 11/02/04 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3907	A

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA823
& Dwg D3907

Dwg Rev: A
folio Rev: SA
Deburr

SA 11/2/16

40 φ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 11/2/16

40 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

mk 11/02/16

40

0

Quality Control

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

SAD 11-02-16

(40)

Packaging

*****STOCK IN BASKET CELL*****

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/02/17

mk

Quality Control

11-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 66090



Parent Item: D3907-1



Parent Item Name: Bushing

Start Date: 2/04/11

Required Date: 2/11/11

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R0.375

Purchased

No

100

f

51.8275

0.03

1.2



SA 11/2/16

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT

51.8275

111323

0

115334

1.1685

116555

50.659

1.3 pt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

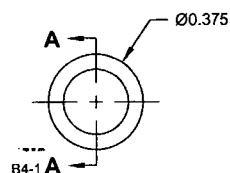
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

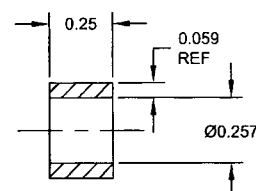
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66090

CX1102104



D3907-1 BUSHING



SECTION A-A C5-1

RELEASED

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

REV.	NEW ISSUE	DESCRIPTION	AJS	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3907 TITLE BUSHING (BASKET REPAIR) SCALE NTS	BY	DATE
DRAWN	AJS			
CHECKED				
MFG. APPR.				
DE APPR.				
DATE	09.03.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON THE ORIGINALLY INTENDED ANY OF THE ORIGINAL "HOLD" WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		